









# Work Order ID 64816

Friday, December 17, 2010 8:00:52 AM




Page 1

Item ID: D3205-1 Accept  Setup Start   
 Revisor ID: Stop   
 Item Name: Pedal Bracket  
 Start Date: 12/16/2010 Start Qty: 4.00  Cust Item ID:  
 Required Date: 1/19/2011 Req'd Qty: 4.00  Customer:  
 Reference:

Approvals: Process Plan:  Date: 12/17 Tooling: Date: Run Start   
 QC: Date: SPC (Y/N): Date: Stop 


Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3205	Rev A								

100		0.00							
	BAND SAW								
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blanks: 3.250" x 2.500" x 4.250" long Bar (+0.030/-0.000)								


SL 11/03/22

(4)

110		0.00							
	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Machine D3205-1 as per Folio FA346 and Dwg D3205 Identify as D3205-1 □ Deburr and Tumble								

ant 11/04/05

(PTC)


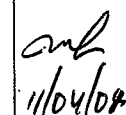
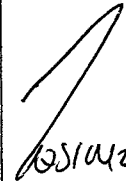
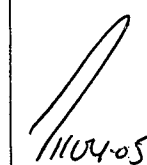
120		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

ant 11/04/05

4 9

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: D3205-1 PAR #: \_\_\_\_\_ Fault Category: machining NCR: Yes No DQA: 11/04/05 Date: 11/04/05  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: 11/4/7 Date: 11/4/7

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
110	01/04/01	1 part scrap - the rad tool go too deep in the part - 040"  R.C. prog. error	 10/10/02	scrap and destroy replace Qty Batch: H116880 Per H. Bellavance	 11/04/05	SL 11/04/05	 10/10/02	 11/04/05

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 64816**

Friday, December 17, 2010 8:00:52 AM

Page 3

Item ID: D3205-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Pedal Bracket

Start Date: 12/16/2010 Start Qty: 4.00

Cust Item ID:

Required Date: 1/19/2011 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

4 0 12/16/10

170

Identify as per dwg &amp; Stock Location: GA

0.00



Packaging

Memo

0.00

Packaging

12/17/10

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

12/17/10

12-04-7  
(4)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Friday, December 17, 2010 8:00:56 AM

Page 1

Work Order ID: 64816



Parent Item: D3205-1



Parent Item Name: Pedal Bracket

Start Date: 12/16/2010

Required Date: 1/19/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP A 04.06.09 New issue KJ/RF  
IPP Rev:B 08-12-16 attach DEO DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M7075T73B2.500X03.2 5		Purchased	No			100	f	0.0000	0.3646	1.535158			



7075-T73 Bar 2.50 x 3.25



SL 11/03/22

1116880

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> <i>64814</i>
<b>Description:</b> Pedal Bracket		<b>Part Number:</b> D3205-1
<b>Inspection Dwg:</b> D3205	<b>Rev:</b> A	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.100	+/-0.010	<i>1.103</i>	<i>—</i>		<i>Vern HL-7</i>	
0.250	+/-0.010	<i>.253</i>	<i>—</i>		<i>"</i>	
R0.37	+/-0.030	<i>R.370</i>	<i>—</i>		<i>Rad-gage</i>	
0.125	+/-0.010	<i>.130</i>	<i>—</i>		<i>Vern HL-7</i>	
0.250	+/-0.010	<i>.260</i>	<i>—</i>		<i>"</i>	
2.380	+/-0.010	<i>2.384</i>	<i>—</i>		<i>"</i>	
1.380	+/-0.005	<i>1.377</i>	<i>—</i>		<i>"</i>	
0.500	+/-0.005	<i>.504</i>	<i>—</i>		<i>"</i>	
0.880	+/-0.010	<i>.882</i>	<i>—</i>		<i>"</i>	
Ø0.470 x 100°	+0.005/-0.000	<i>Ø.475 x 100°</i>	<i>—</i>		<i>"</i>	
0.440	+/-0.005	<i>.440</i>	<i>—</i>		<i>"</i>	
0.600	+/-0.005	<i>.596</i>	<i>—</i>		<i>"</i>	
1/4-28UNF-313	N/A	<i>1/4-28UNF-313</i>	<i>—</i>		<i>N/A</i>	
0.250	+/-0.010	<i>.250</i>	<i>—</i>		<i>Vern HL-7</i>	
Ø0.257	+0.005/-0.000	<i>Ø.258</i>	<i>—</i>		<i>"</i>	
1.750	+/-0.010	<i>1.750</i>	<i>—</i>		<i>"</i>	
0.870	+/-0.005	<i>.867</i>	<i>—</i>		<i>"</i>	
0.440	+/-0.005	<i>.440</i>	<i>—</i>		<i>"</i>	
R0.25	+/-0.030	<i>R.250</i>	<i>—</i>		<i>"</i>	

<b>Measured by:</b> <i>Amf</i>	<b>Audited by:</b> <i>N</i>	<b>Prototype Approval:</b>	N/A
<b>Date:</b> <i>11/04/05</i>	<b>Date:</b> <i>11/04/05</i>	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

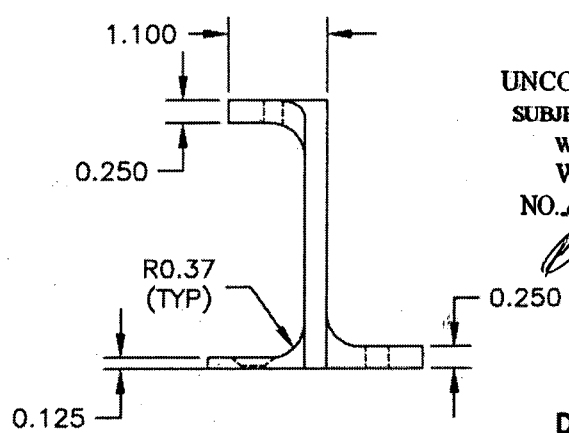
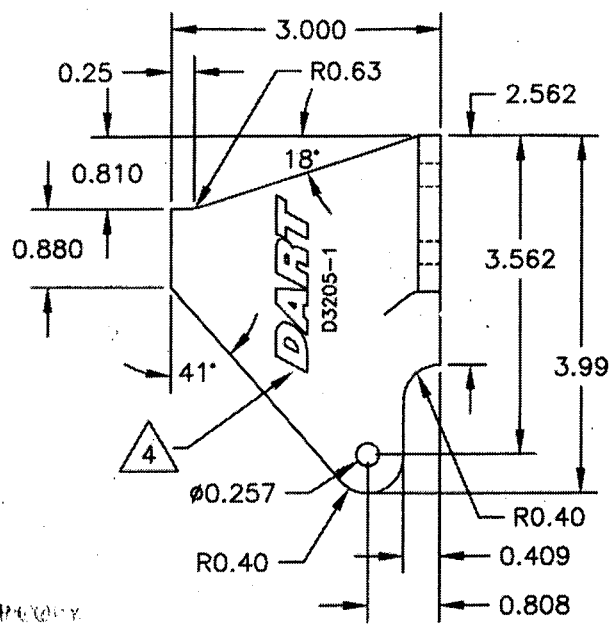
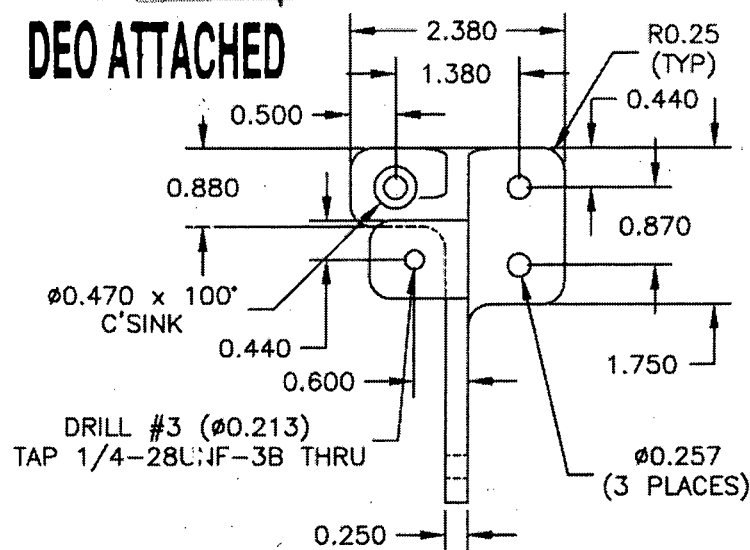
**NOTE:** Date & initial all entries



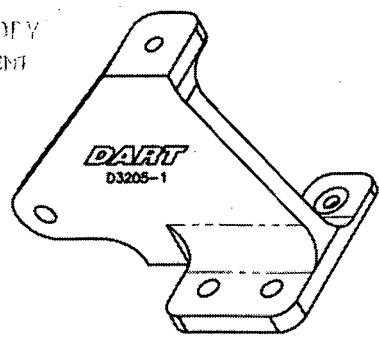
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3205	REV. A SHEET 1 OF 2
DATE 04.01.27		TITLE BRACKET	SCALE 1:2
A	04.01.27	NEW ISSUE	

RELEASED  
04.04.05

DEO ATTACHED



SHOP COPY  
RETURN TO  
ENGINEERING.  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 64816  
01/02/17



D3205-1 PEDAL BRACKET

NOTES:

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 7075-T73 (QQ-A-200/11 OR QQ-A-250/12)  
OR 2024-T3 (QQ-A-200/3 OR QQ-A-250/4)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ENGRAVE DART P/N & LOGO AS SHOWN
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE INCHES

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

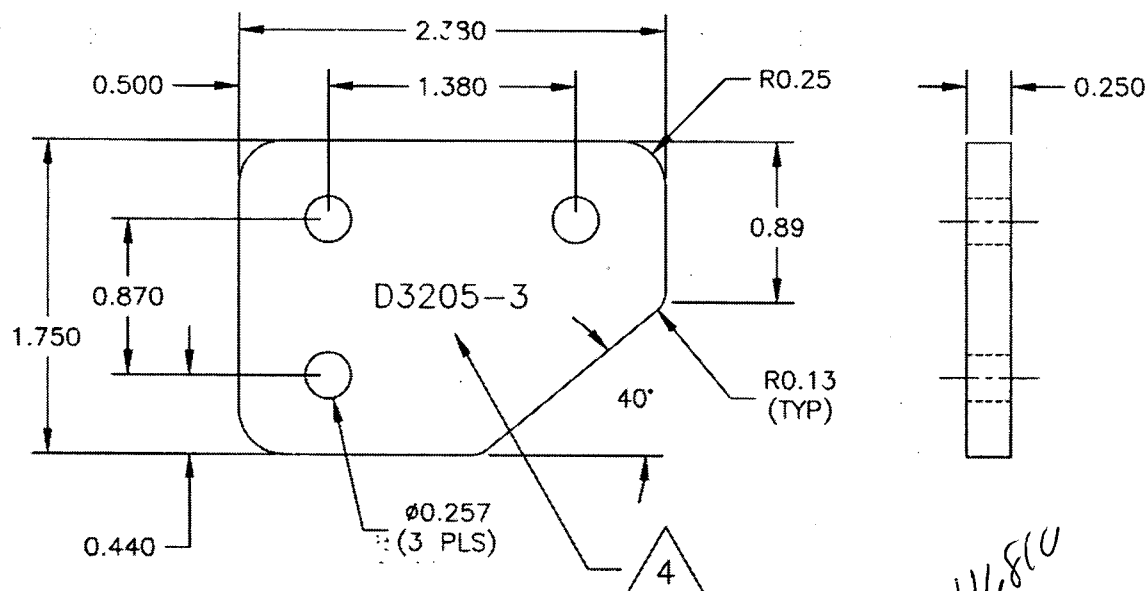


DESIGN	DRAWN BY	DART AEROSPACE LTD
04.01.27		HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
04.01.27		D3205
DATE	TITLE	SHEET 2 OF 2
	BRACKET	SCALE
		1:1

RELEASED  
04.01.27

DEO ATTACHED

Wk H6810



### D3205-3 BACK PLATE

#### NOTES:

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)  
ALUMINUM BAR (M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ENGRAVE DART P/N AS SHOWN
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE INCHES

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

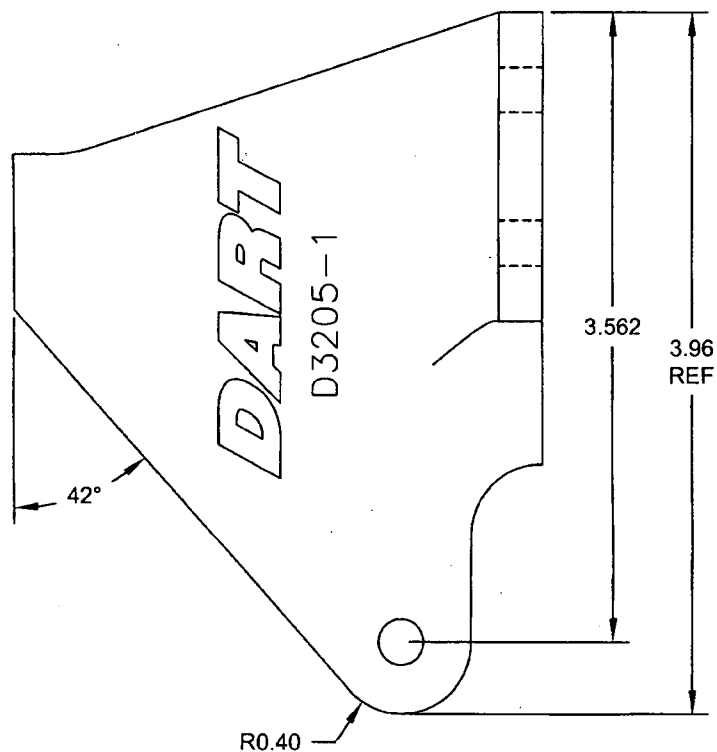
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

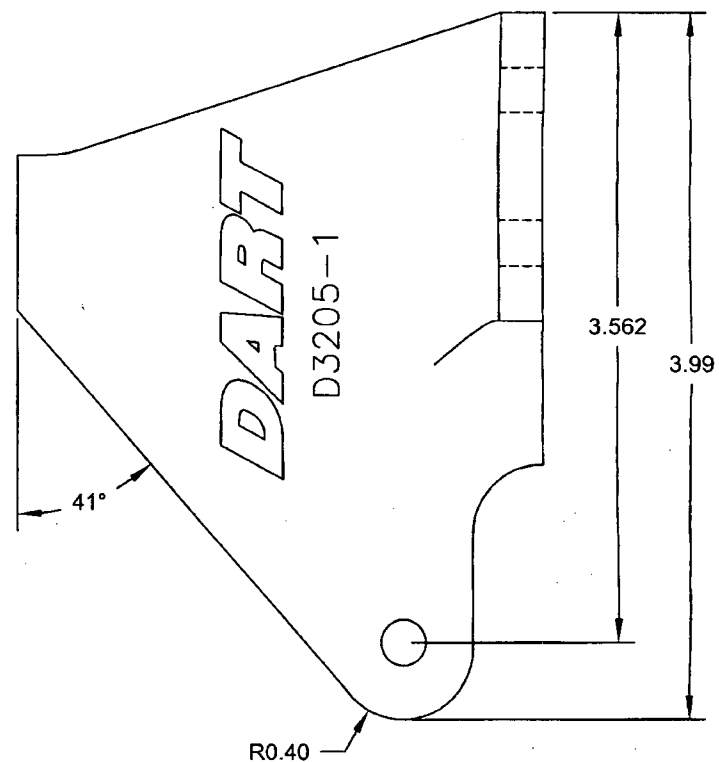
DRAWING NO. D3205	TITLE BRACKET	REV. A	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D3205-A-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED <i>ls</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DE APPR. <i>[Signature]</i>		
DATE 08.12.01	DATE 08.12.01	DATE 08/12/01	DATE 08/12/01	DATE 08.12.01		

SHEET 1 MODIFY D3205-1 AS SHOWN:

IS:



WAS:



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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng				Sign & Date

**NOTE:** Date & initial all entries